

Date: Wednesday, 21/05/2008 11:30:15 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : ANGLE-PROTO

Job Number : 05003

Estimate Number : 10804

P.O. Number :

This Issue : 21/05/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : R & D SM/MED FAB

Previous Run : 05002

Part Number : D37093 *PROTOTYPE 08.05.20*

Drawing Number : D3709

Project Number :

Drawing Revision :

Material :

Due Date : 28/05/2008 Qty: 1 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

PROTOTYPE
PRELIMINARY ISSUE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 MAKE PER DRWG D3709 REV.A

JB 08.05.21

2.0

M6061T6S063

6061-T6 .063 Sheet



Comment: Qty.: 0.5000 sf(s)/Unit Total : 0.5000 sf(s)
 angle 750 x 750 x .1/16w

1107387

JB 08.05.21

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
 APPROVAL**

JB 08.05.21

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 ACID ETCH AND ALODINE

Not required JB

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required JB

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 ENGINEERING -MARC

JB 08.05.21

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Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



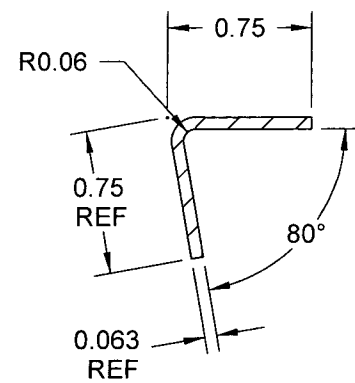
Comment: FINAL INSPECTION/W/O RELEASE

JA-08.05-22

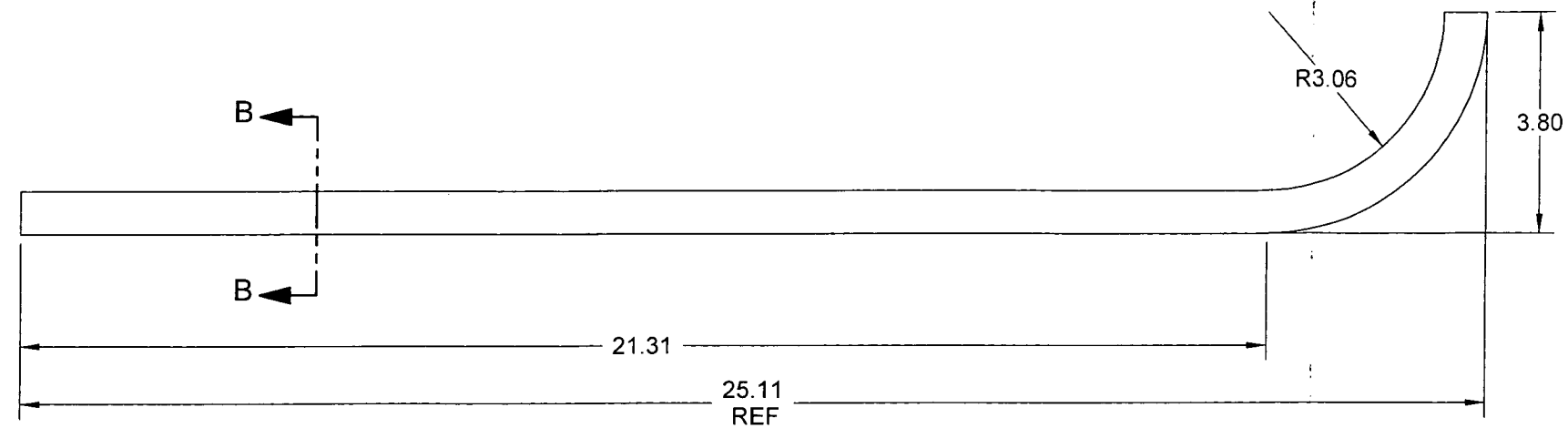
Job Completion



Prototype
MF 08-06-12

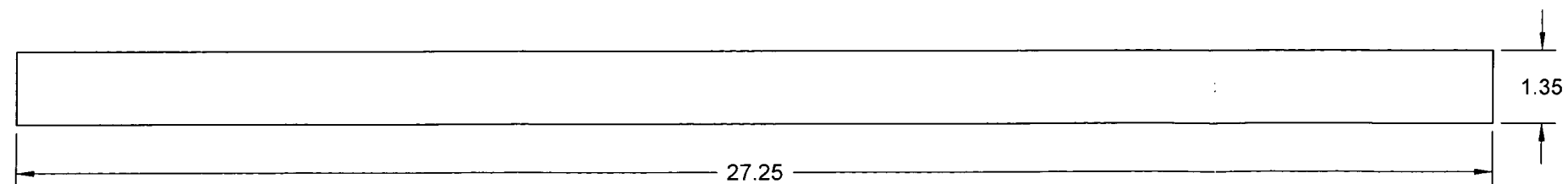


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

PROTOTYPE
08.05.20
PRELIMINARY ISSUE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
DATE	08.05.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

VENDU À /
SOLD TO:

LIVRÉ À /
SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CUSTOMER PURCHASE	
0165970		DART		5851	
LIVRÉ VIA / SHIP VIA		CONDITIONS - TERMS		DATE COMMANDE DATE ORDER	
NIR:R-557065-1		NET 30		Mar-	
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D			CONTRÔLE DE QUALITÉ D MAGNA QUALITY		
QUALITÉ - QUALITY		UNITÉ UNIT	N° DE COULÉE HEAT NUMBER	DESCRIPTION	
COMMANDES ORDERED	A VENDU - B/O				
4 Pcs 8		lbs	F11503CR	304L ROUND 1/4" DIA	
2 Pcs 26		lbs	41043	6061-T6 ALUM 3/4 SQ USE MTR #CA533	
3 Pcs 131		lbs	1628331	6061-T6 .063 X 48 X USE MTR #BZ853	
5 Pcs 443		lbs	412603	6061-T6 AL FLAT 1 1 USE MTR #CE459	
TOTAL :					

OMBRE DE PAQ.
NUMBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER ☒

POSTE
MAIL ☐

TÉLÉCOPIEUR
FAX ☐

Page: 1

08:50:24

20080311

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

H:\FORMS\Purchasing\approved purchase\RECREPORT Rev D

Production/Admin:
Date
Received/Costing
Initial

Location

Initials of receiver (if shipment OK) Level 12

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M 20478040		108	0	0	108	
M 6061 T6 3/16 X 1016		20			20	

Discrepancies

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☐ No ☒
QC6 Inspection: Yes ☐ No ☒
Work Order: ☐

Supplier: MACVA

Part P/O: 5851

Batch No: 1717367

Receiving Report

BZ 853

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NRBST : 03484/04

PAGE : 1/ 2

INSPECTION CERTIFICATE

Aleris

Europe

CUSTOMER : ALERIS ALUMINUM US SALES INC.

YOUR ORDER NUMBER : P08858 (CHARLESTON PO#5001-E)
 OUR ORDER NUMBER : 03484/04
 DOCUMENT NUMBER : V/0080236963

Aleris Aluminum Duffel BVBA
 A. Stockelaan 87, 2570 Duffel - Belgium

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04
 DIMENSIONS : 144" X 48" X .063"
 ARTICLE NO. :

0863/12

COIL
NUMBER

CASE
NUMBER

CHEMICAL COMPOSITION (%)

		SI	FE	CU	MN	MG	CR	TI	ZN
	MIN	0,40		0,15		0,8	0,04		
	MAX	0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
004	1628301	0,62	0,4	0,19	0,07	1,0	0,15	0,03	0,05
005	1628331	0,68	0,4	0,20	0,08	1,0	0,17	0,02	0,03

OTHERS : EACH
TOTAL :

MIN
MIN

0,05 MAX
0,15 MAX

MECHANICAL PROPERTIES

TEST- (T) = TRANSVERSAL (L) = LONGITUDINAL
 NUMBER 1 N/MM2 = 1 MPA = 0,1 HBAR 0,102 KG/MM2 = 0,145 KSI
 /A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

		RM	RP02	A
		KSI	KSI	%
	MIN	42	35	10
	MAX			
004	/A	50	42	13
004	/M	49	42	16
004	/V	50	41	13
005	/A	50	41	16
005	/M	50	41	13
005	/V	50	41	18

Aleris Aluminum Duffel BVBA

59983
24/12

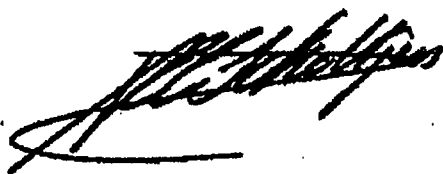
Aleris

Europe

Aleris Aluminum Duffel BVBA
A. Stockman 67, 2670 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER
004 STENCILLING : WEEK 17 / YEAR 2007
005 STENCILLING : WEEK 17 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS



Aleris Aluminum Duffel BVBA